

Thursday, 2/14/2008 10:54:17 AM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: REPLACEMENT WINDOW ASSEMBLY		
Job Number	: 37414			Part Number	: D3290041		
Estimate Number	: 11174			Drawing Number	: D3290 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	2/14/2008	S.O. No.	:	Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	:	/ /	Type	SMALL /MED FAB	Due Date	2/22/2008	Qty: 12 Um: Each
Previous Run	: 37033						
Written By	<u>PH 08 02 14</u>						
Checked & Approved By							
Comment	: Est. B 06.05.25 Added Step 11 KJ/JLM Est. C 06.05.09 Ecn 798 EC Est Rev:D Now on Waterjet 06-06-16 JLM Est rev E rev C dwg 07.09.28 EC verified by: DD						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S040	6061-T6 .040 Sheet
		 Comment: Qty.: 3.9375 sf(s)/Unit Total : 47.2500 sf(s) <u>5052</u> <u>106900 X 9</u> <u>M6061T6S040</u> <u>7106747 * 3 +</u> <u>BS 8-2-15</u>
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut as per Dwg D3290 (use prog. for D3290-1) Dwg Rev: <u>C</u> <u>BS 8-2-15</u> Prog Rev: <u>C</u> <u>BS 8-2-15</u> 2-Deburr if necessary <u>BS 8-2-15</u> <u>10803/03/12</u> <u>12</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <u>BS 8-2-15</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		 <u>BS 8-2-15</u> <u>08/03/12 X/12</u> <u>12</u>
		Comment: SECOND CHECK
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		 <u>BS 8-2-15</u> <u>12X</u>
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1
		<u>M-1</u> <u>08/03/13</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 37414		Part Number: D3290041													
Job Number: 															
Seq. #:	Machine Or Operation:	Description:													
6.0	POWDER COATING	POWDER COATING	 (12x)												
		M1007005													
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		m-f. 08/03/15													
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION													
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		0 m	08. 03. 15 (12)												
8.0	D2126	Seal													
Comment: Qty.: 6.5000 f(s)/Unit Total : 78.0000 f(s) Locking Seal Pick: <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>1</td><td>D2126-0780</td><td>Locking Seal</td><td>B34718 (3)</td></tr><tr><td></td><td></td><td></td><td>B3525 (9)</td></tr></table>		Qty	Part Number	Description	Batch	1	D2126-0780	Locking Seal	B34718 (3)				B3525 (9)	SAD 08/03/30 (12)	
Qty	Part Number	Description	Batch												
1	D2126-0780	Locking Seal	B34718 (3)												
			B3525 (9)												
9.0	D32903	Window													
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) Window Pick: <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>1</td><td>D3290-3</td><td>Window</td><td>B34957</td></tr></table>		Qty	Part Number	Description	Batch	1	D3290-3	Window	B34957	AS 08/03/18 (10)					
Qty	Part Number	Description	Batch												
1	D3290-3	Window	B34957												
10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1													
Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D3290 Clean D3290-041 and place in plastic wrap		SAD 08/03/30 (12)													
11.0	QC5	INSPECT WORK TO CURRENT STEP													
Comment: INSPECT WORK TO CURRENT STEP		S 08/03/31 (17)													
12.0	PACKAGING 1	PACKAGING RESOURCE #1													
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: SD218		P 08/03/31 (12)													

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 37414

Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/01/02
AJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf

08-03-31

U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

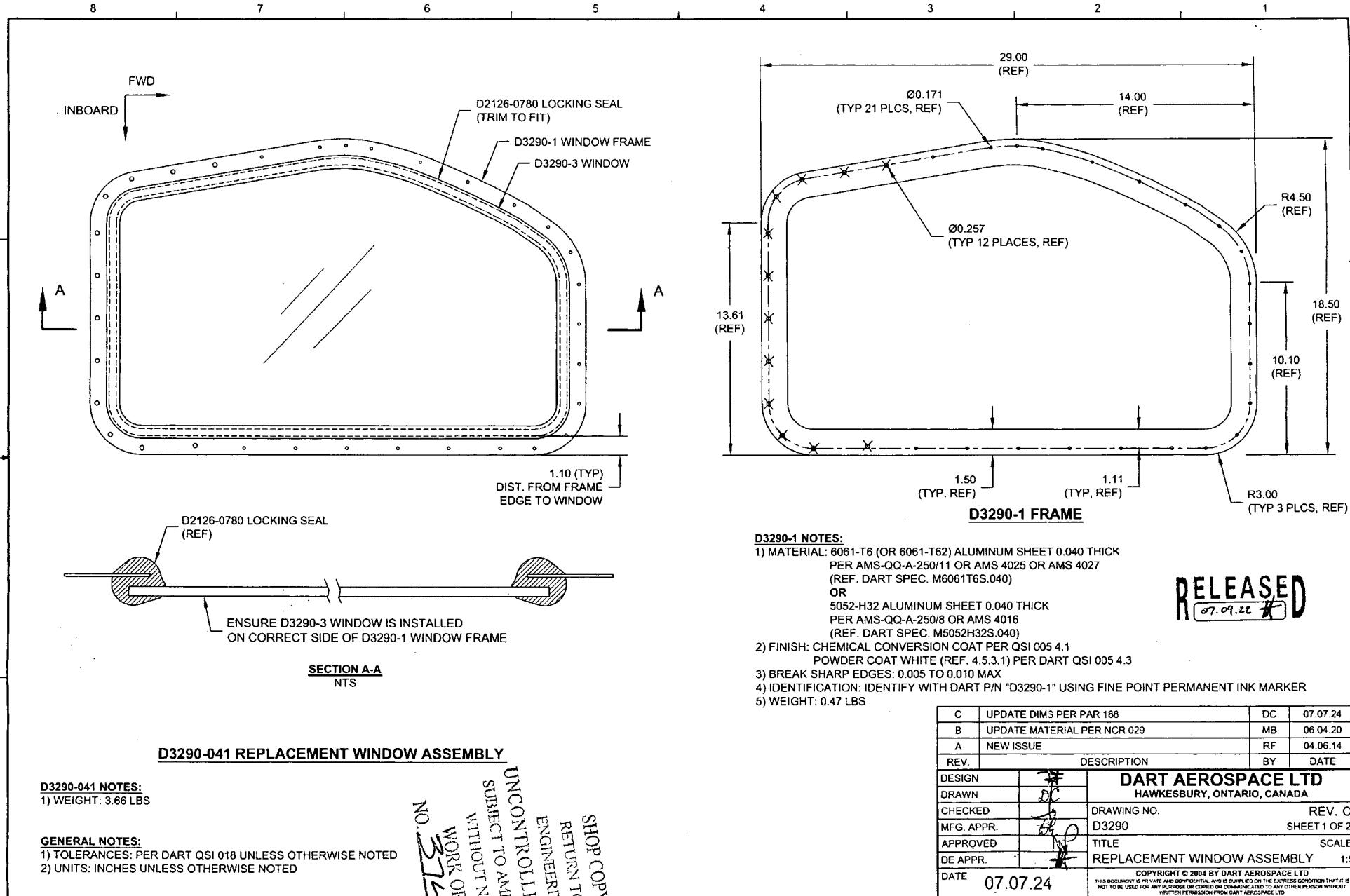
DART AEROSPACE LTD	Work Order:	37414
Description: Window Frame	Part Number:	D3290-1
Inspection Dwg: D3290	Rev: C	Page 1 of 1

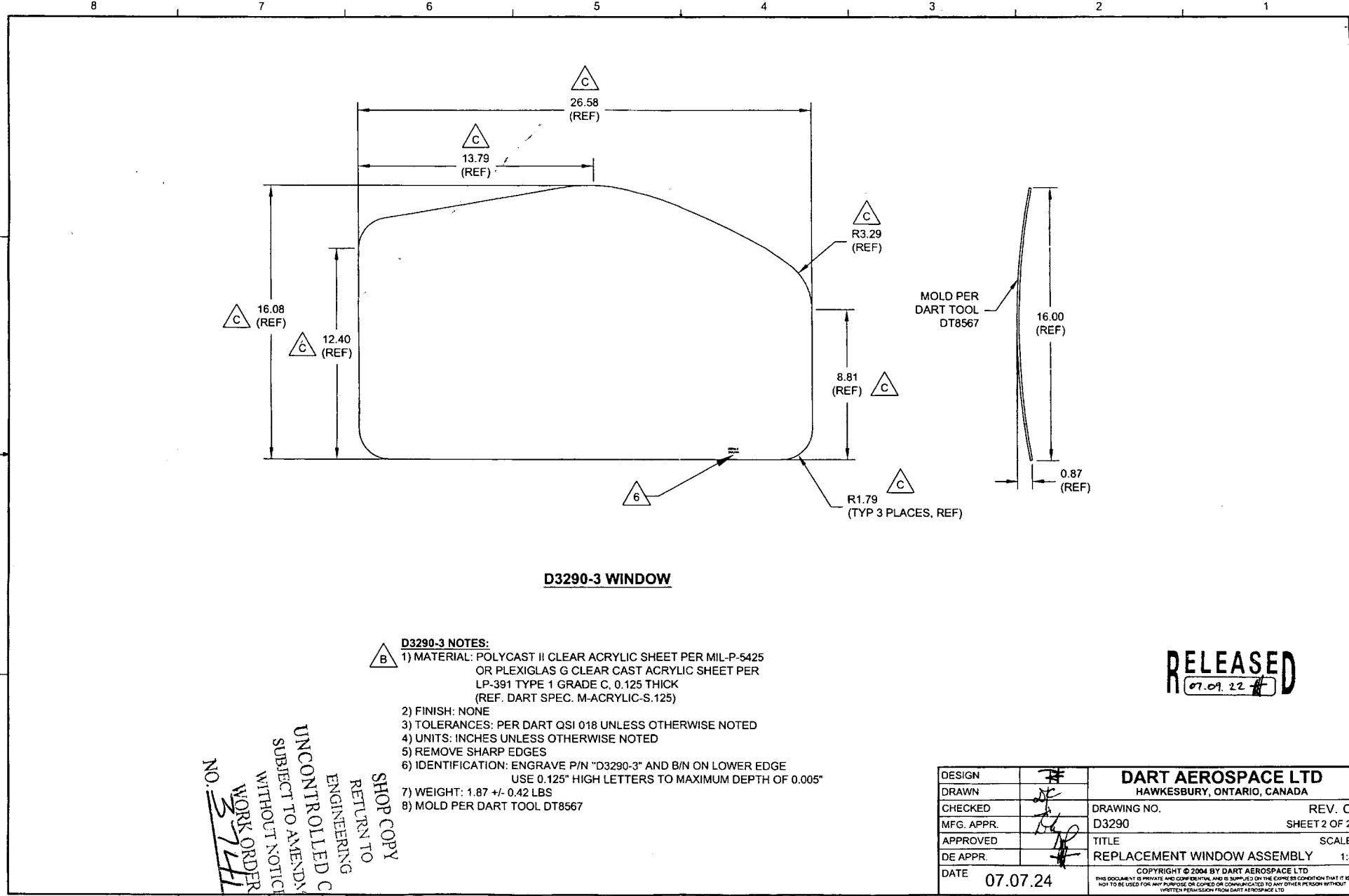
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>LR</u>	Audited by: <u>L</u>	Prototype Approval: N/A
Date: 8-2-15	Date: 08/02/15	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue P/O D3290-041	KJ/JLM	
B	07.07.18	13.61 dimension removed	KJ/JLM	
C	07.09.28	Dimensions update per Dwg Rev C	KJ/EC/DD	RE





DESIGN	REV	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	<u>7</u>	
CHECKED	<u>7</u>	DRAWING NO. REV. C
MFG. APPR.	<u>7</u>	D3290 SHEET 2 OF 2
APPROVED	<u>7</u>	TITLE SCALE
DE APPR.	<u>7</u>	REPLACEMENT WINDOW ASSEMBLY 1:5
DATE	07.07.24	

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